

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STUB COVER
Job Number	: 28946		
Estimate Number	: 12415		
P.O. Number	: N/A	Part Number	: D34941
This Issue	: 10/11/2006 S.O. No. : N/A	Drawing Number	: D3494 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 28725	Material	: N/A
Written By	: _____	Due Date	: 10/30/2006
Checked & Approved By	: <u>HA 061011</u>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 06-05-18 JLM		

Job Number:



1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.6972 sf(s)/Unit Total : 13.9440 sf(s)

304/316 .063 Sheet

(M304S16GA)

Batch: ml 06 10 12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3494

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary.

SAD 06-10-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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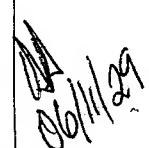
Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3494

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes 6 No 2 DQA: 2 Date: 06/12/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/27	5	1 piece was map drawing under review		Scrap & destroy	SS 06/11/27	 06/11/29	 0322	 06/11/29

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 12:50:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUB COVER

Job Number: 28946

Part Number: D34941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/11/29

19

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3494

A/R SS ROD Batch: M102756

12/06/12/13

19

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/12/13

19

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/12/13

19

10.0

POWDER COATING

POWDER COATING



M100700



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-R/CM

06/12/20

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12/12/21

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5783

12/12/21

19

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/06/12/22

19

Job Completion



W.D. 12/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

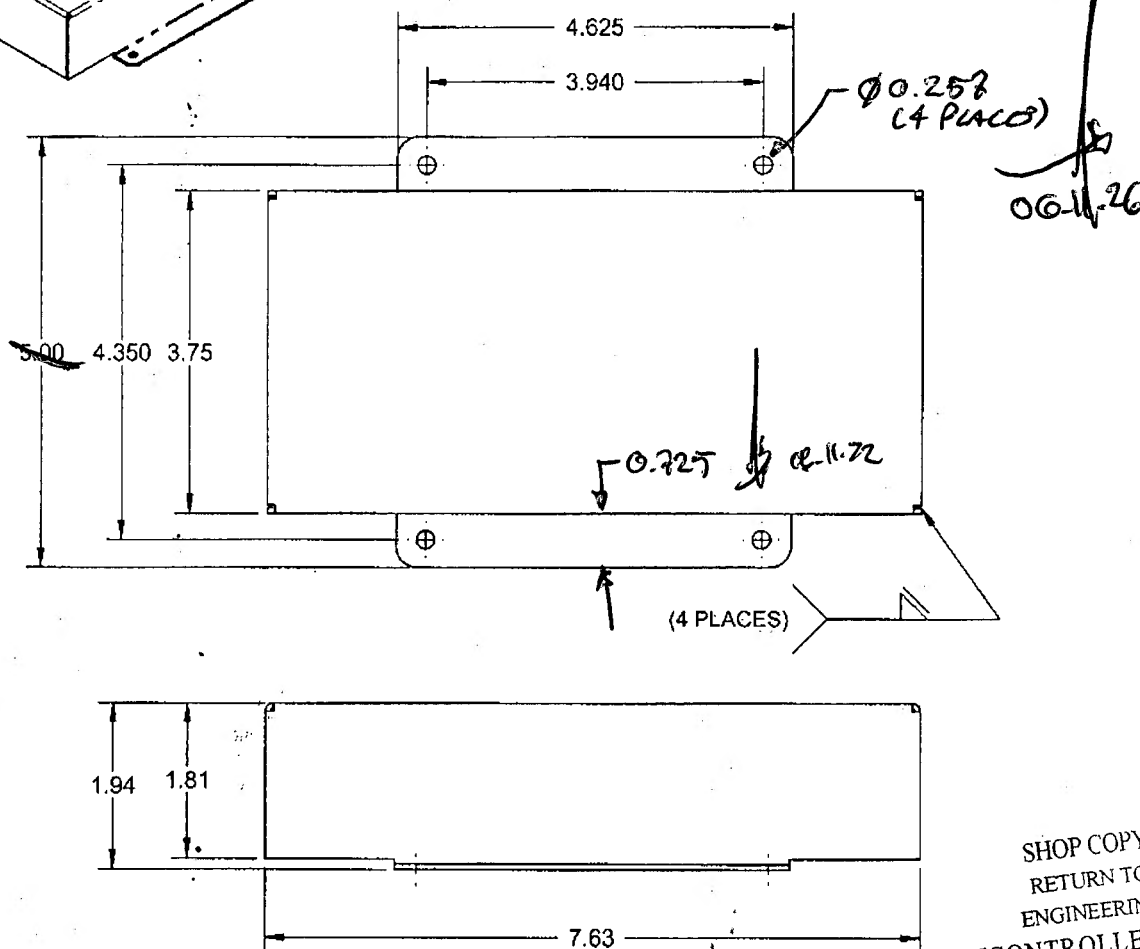
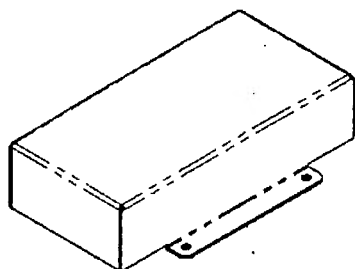
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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DATE 06.01.16	TITLE STUB COVER		SCALE 1:2
A	06.01.16	NEW ISSUE	

**NOTES:**

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

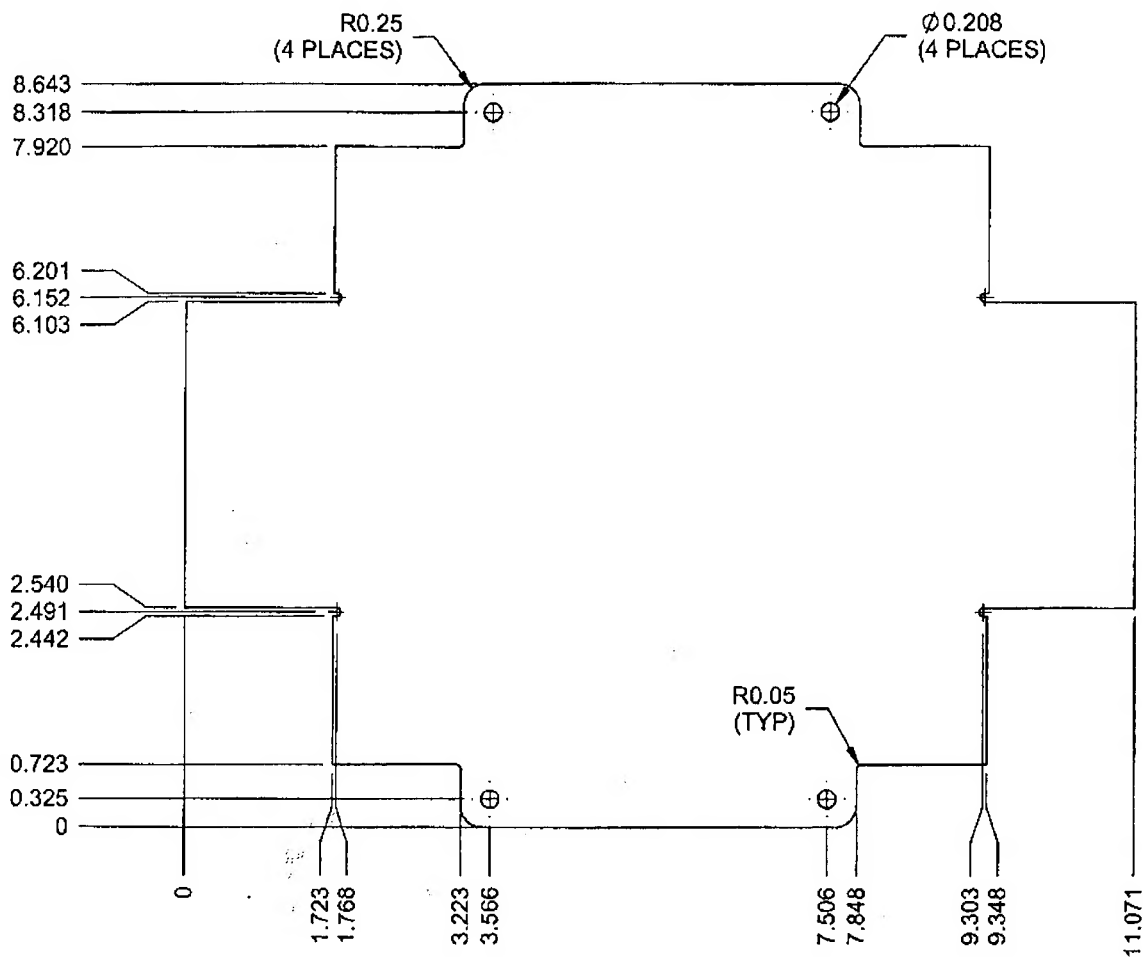
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DATE 06.01.16	TITLE STUB COVER		SCALE 1:2

**D3494-1F STUB COVER FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.060 THICK) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

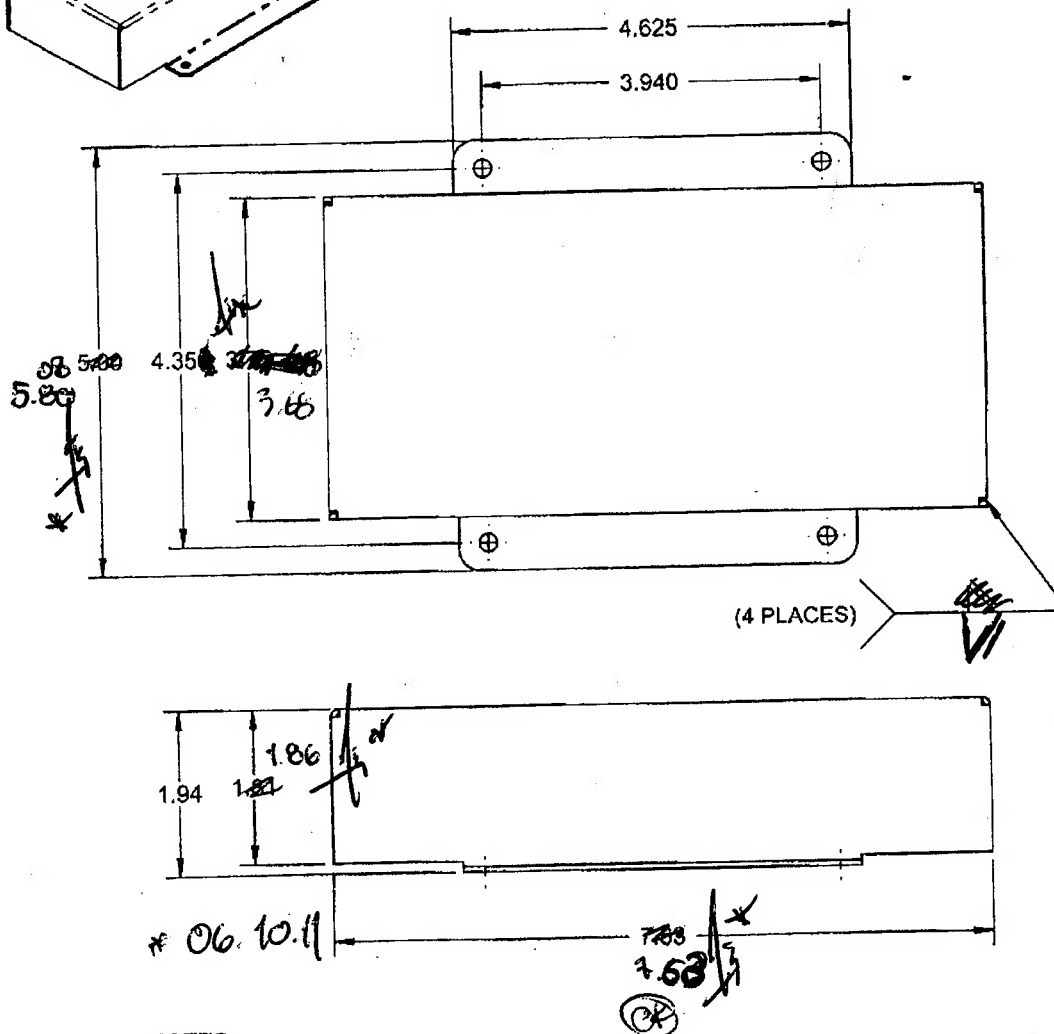
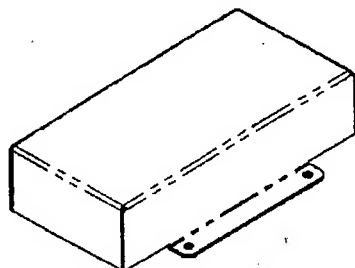
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CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3494	REV. A SHEET 1 OF 2
DATE 06.01.16	TITLE STUB COVER		SCALE 1:2
A	06.01.16	NEW ISSUE	



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